

Please do ASAP

Work Order ID 142135

142135

Page 1

February 29, 2016 10:19:29 AM

Item ID: D3675-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop *NS2*

Item Name: Sliding Door Bracket

Start Date: 2/29/2016 Start Qty: 60.00

60

60 SA

Cust Item ID:

Required Date: 3/2/2016 Req'd Qty: 60.00

60

60

60

Customer:

Reference:

Approvals:

Process Plan: SA

Date:

20160229

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3675

RevD

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.05

FLOW CNC Waterjet

1-Cut as per Dwg D3675

Dwg Rev: A

Prog Rev: D

2-Deburr if necessary

(62)

02/16/03/02

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.01

Quality Control

(62)

02/16/03/02

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.02

Quality Control

(61)

DAS
38
9-89

MAR 02 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 142135

142135

Page 2

February 29, 2016 10:19:29 AM

Item ID: D3675-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Sliding Door Bracket
 Start Date: 2/29/2016 Start Qty: 60.00 ***60*** Cust Item ID:
 Required Date: 3/2/2016 Req'd Qty: 60.00 ***60*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	NC BRAKE				DAS				
Brake NC	Memo	0.03			30	61			MAR 04 2016
Brake NC	Form as per Dwg D3675 use DT9723				9-89				
140		0.00							
140	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.02				61			DAS 38 9-89
Quality Control									MAR 04 2016
150		0.00							
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3								
Powdercoat	Memo	0.01							DAS 34 9-89
Powder Coating	START TIME: 1:40 OVEN TEMPERATURE: 320° FINISH TIME: 2:10					61	16-03-7		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 142135

February 29, 2016 10:19:29 AM

142135

Please cut ASAP
Bell/CCG order.

Page 3

Item ID: D3675-1 Accept *N9000040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Sliding Door Bracket
Start Date: 2/29/2016 Start Qty: 60.00 *60* Cust Item ID:
Required Date: 3/2/2016 Req'd Qty: 60.00 *60* Customer:
Reference:

Approvals: Process Plan: 5th Date: 20160229 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									DAS
QC	Memo	0.01							38
Quality Control									MAR 08 2016
170	Identify as per dwg & Stock Location: <u>Stoso</u>	0.00							
170									
Packaging	Memo	0.01							DAS
Packaging									6
									9-89
									MAR 08 2016
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.10							
Quality Control									MCS
									MAR 08 2016

MCS MAR 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

February 29, 2016 10:19:35 AM

Page 1

Work Order ID: 142135

142135

Parent Item: D3675-1

D3675-1

Parent Item Name: Sliding Door Bracket

Start Date: 2/29/2016

Required Date: 3/2/2016

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP Rev:A new issue 08-04-21 DD verified by:EC IPP Rev:B
11.01.11 as per dwg rev.C DD verified by:EC IPP Rev C 11.03.31
ECN 11-531 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	77.6000	0.121	7.642105			

M304S20GA

304/316 .040 Sheet

2/16/23/07

Location

Loc Qty

Loc Code

MAT020

33.6

m134067

33.6

MAT20

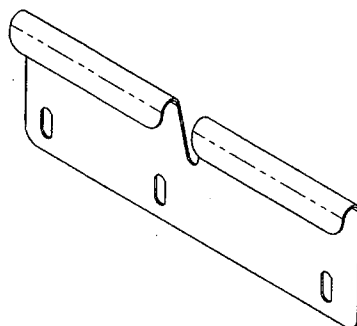
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m133901

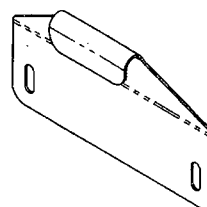
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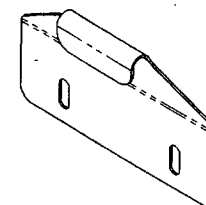
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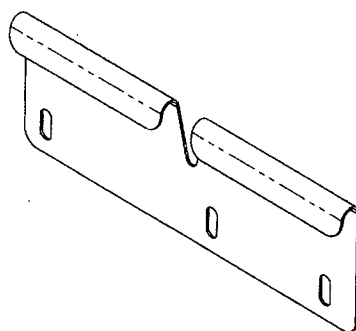
D3675-5 SLIDING DOOR BRACKET



D3675-1 SLIDING DOOR BRACKET



**D3675-3 SLIDING DOOR BRACKET
(HINGE PANEL MOD)**



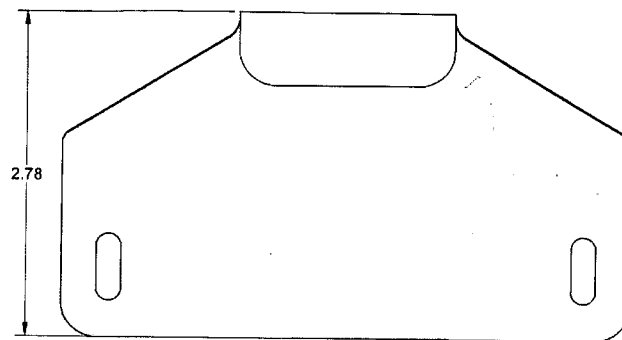
D3675-6 SLIDING DOOR BRACKET

20160229

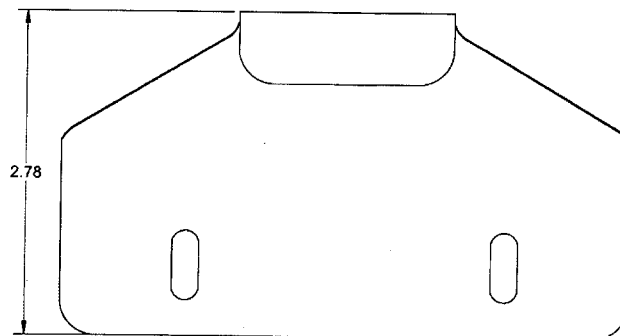
RELEASED
2011-03-31

SA 142135

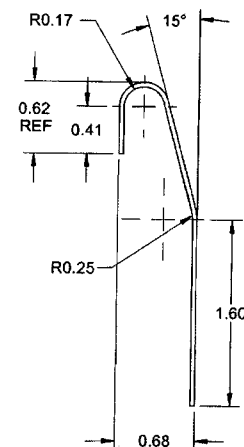
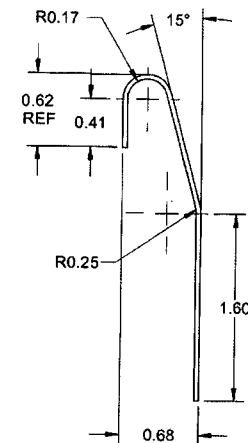
REV.	DESCRIPTION	BY	DATE
D	RE-DESIGNED D3675-5/-6/-6 PER CUSTOMER FEEDBACK TO ELIMINATE BINDING OF DOOR ONCE BRACKETS ARE INSTALLED. REF.: PAR11-79.	MB	11.03.21
C	ADD -5/-5F/-6 BRACKET	MB	10.12.17
B	ADD -3 FOR HINGE PANEL MOD.	AJS	08.11.03
A	NEW ISSUE	AJS	08.03.27
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.03.21		
		DRAWING NO. D3675	REV. D
		TITLE SLIDING DOOR BRACKET (COMPOSITE DOOR)	SHEET 1 OF 6
		SCALE NTS	
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D3675-1 SLIDING DOOR BRACKET
(MAKE FROM D3675-1F)



D3675-3 SLIDING DOOR BRACKET
(MAKE FROM D3675-3F)
(HINGE PANEL MOD)



RELEASED
R 2011-03-31
JMP

NOTES:

- 1) MATERIAL: SEE SHEET 5
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-X" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.15 lbs EACH
- 8) THE D3675-1 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-1 BRACKET.

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.	AS	D3675	SHEET 2 OF 6
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	SLIDING DOOR BRACKET (COMPOSITE DOOR)	NTS
DATE	11.03.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

D

D

C

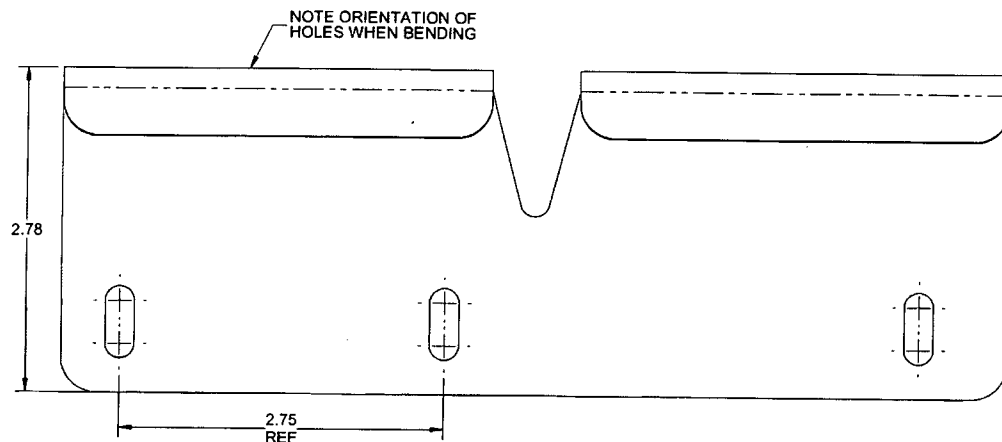
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B

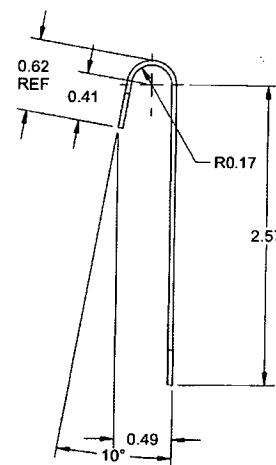
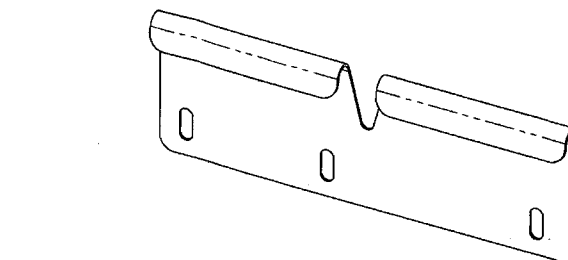
B

A

A



D3675-5 SLIDING DOOR BRACKET
(MAKE FROM D3675-5F)



RELEASED
R 2011-03-30
JW

NOTES:

- 1) MATERIAL: SEE SHEET 6
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-5" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.31 lbs EACH
- 8) THE D3675-5 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-3 BRACKET.

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	A		
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	DS	D3675	SHEET 3 OF 6
APPROVED	AD	TITLE	SLIDING DOOR BRACKET
DE APPR.	SH	(COMPOSITE DOOR)	SCALE
DATE	11.03.21		NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D

D

C

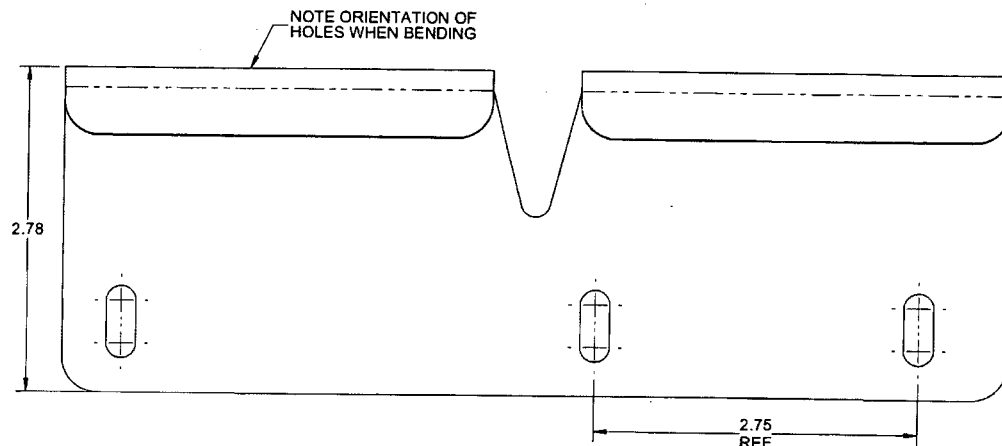
C

B

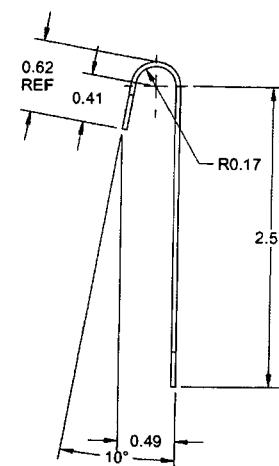
B

A

A



D3675-6 SLIDING DOOR BRACKET
(MAKE FROM D3675-SF)



RELEASED
2011-03-31
MP

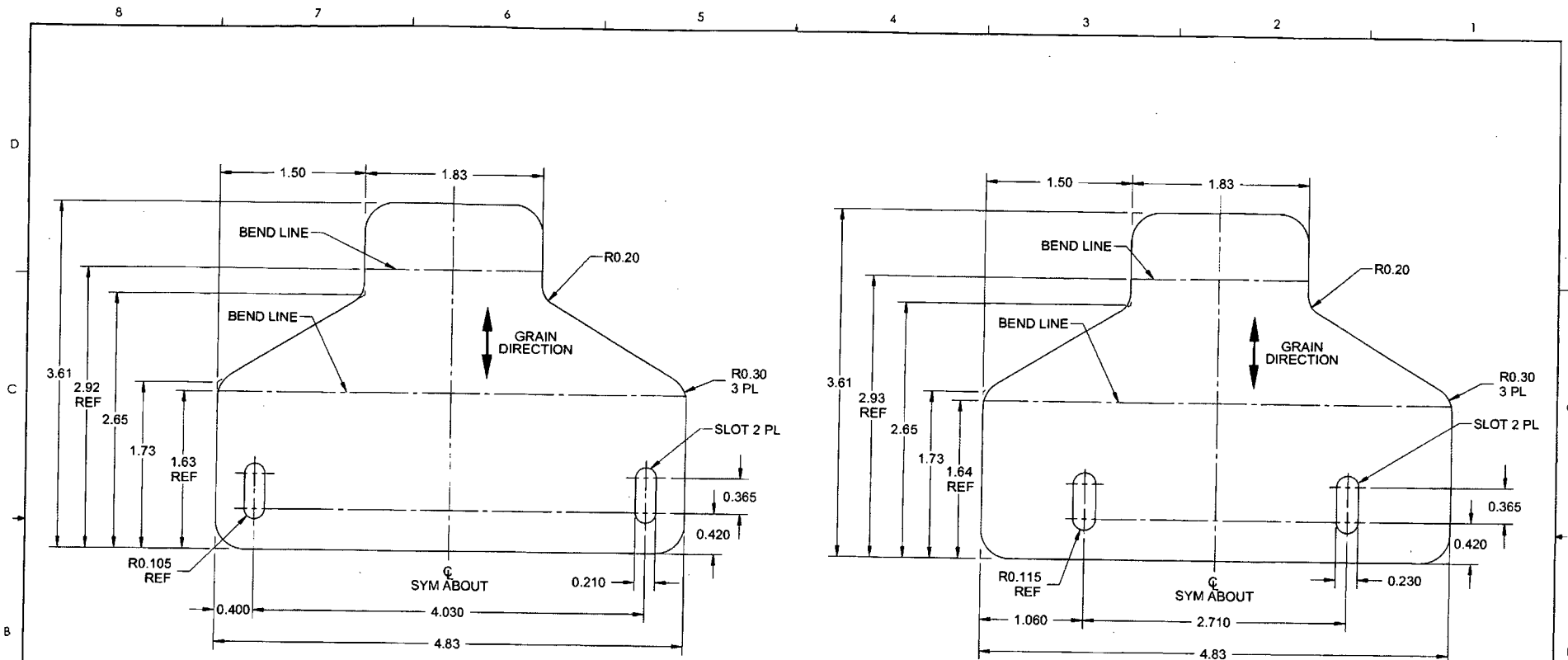
NOTES:

- 1) MATERIAL: SEE SHEET 6
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-6" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.31 lbs EACH
- 8) THE D3675-6 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-4 BRACKET.

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.	AS	D3675	SHEET 4 OF 6
APPROVED	AS	TITLE	SLIDING DOOR BRACKET
DE APPR.	AS	(COMPOSITE DOOR)	SCALE
DATE	11.03.21		NTS

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8 7 6 5 4 3 2 1



D3675-1F FLAT PATTERN

D3675-3F FLAT PATTERN

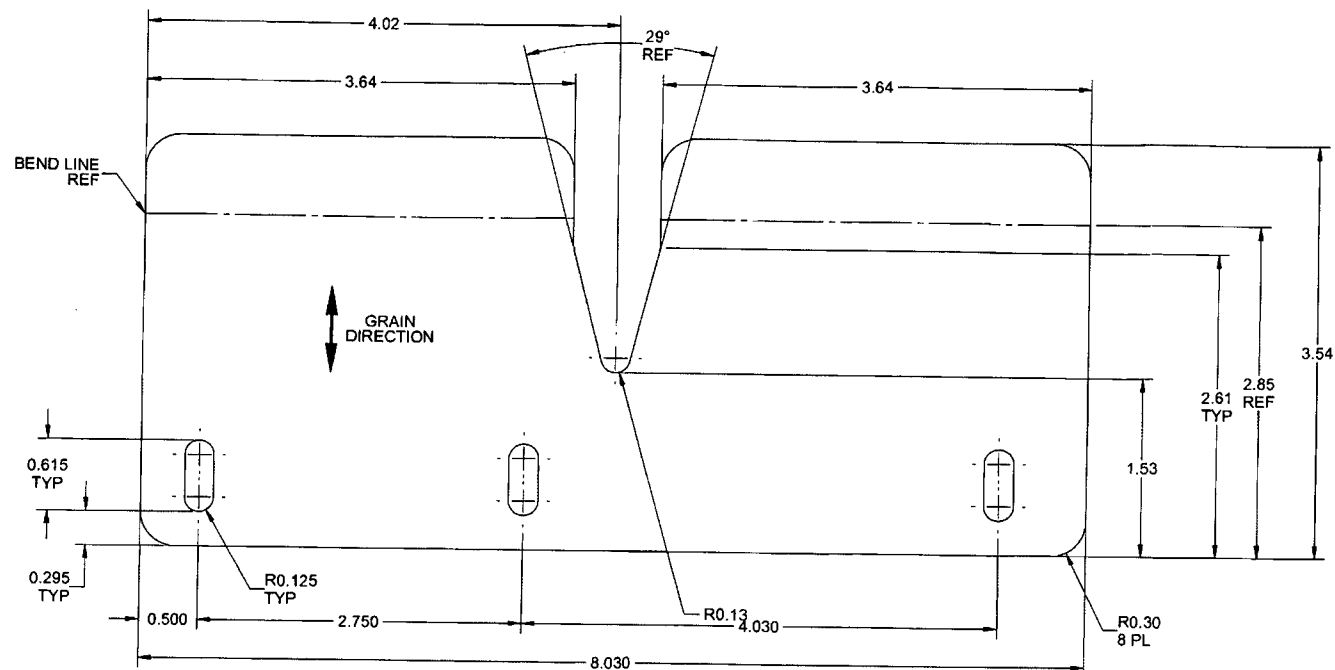
RELEASED
R 2011-03-31
MP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED) OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.15 lbs EACH

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	B	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	N	D3675	SHEET 5 OF 8
APPROVED	MP	TITLE	SLIDING DOOR BRACKET
DE APPR.	MP	(COMPOSITE DOOR)	SCALE
DATE	11.03.21		NTS

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D3675-5F FLAT PATTERN

RELEASED
2011-03-31

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED) OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs

DESIGN	<i>AS</i>	DART AEROSPACE LTD	
DRAWN	<i>B</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>AS</i>	D3675	SHEET 6 OF 6
APPROVED	<i>AS</i>	TITLE	SLIDING DOOR BRACKET
DE APPR.	<i>AS</i>	(COMPOSITE DOOR)	SCALE
DATE	11.03.21	NTS	

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